

Work Order ID 151772

Friday, December 09, 2016 10:50:24 AM

151772

Page 1

Item ID: D206-648-013
 Revision ID:
 Item Name: Ground Handling Wheel Modification
 Start Date: 10/3/2016 Start Qty: 6.00
 Required Date: 10/7/2016 Req'd Qty: 6.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: **DAS 21 9-89** Date: **DEC 09 2016**
 QC: Date: SPC (Y/N):

Tooling:

Date:

Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D206-648	Rev B								

100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-648-013 CHG002								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS 6 9-89

DAS 21 9-89

DAS 28 9-89

DEC 19 2016

DAS 6 9-89

DEC 16 2016

DAS 28 9-89

DEC 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
240 08-0				240 08-0			Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
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Page 2

Item ID: D206-648-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ground Handling Wheel Modification

Start Date: 10/3/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/7/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-648-013

*Sto36*DAS
28
9-89DAS
27
9-89

DEC 19 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

DEC 19 2016

DAS
21
9-89

DEC 19 2016

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Picklist Print

Friday, December 09, 2016 10:50:31 AM

Page 1

Work Order ID: 151772

151772

Parent Item: D206-648-013

D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A05.09.23New issueKJ/JLM
IPP Rev:B 07-12-05 ECN 1080p DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2652		Manufactured	No			110	Each	218.0000	8	48			
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D2652

Bushing

**

DAS
6
9-89

DEC 16 2016

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST009	174	
150988	174	

mf

D3414-041		Manufactured	No			110	Each	54.0000	2	12			
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D3414-041

Lug

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DAS
6
9-89

DEC 16 2016

DAS
28
9-89

Location	Loc Qty	Loc Code
ST531	30	
147135	18	
148302	4	
150678	8	
ST532A	24	
147135	0	
153514	24	

4
8

mf

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Picklist Print

Friday, December 09, 2016 10:50:31 AM

Page 2

Work Order ID: 151772

151772

Parent Item: D206-648-013

D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

AN3C37A

Purchased

No

110

Each

270.0000

4

24

AN3C37A

BOLT

**

DAS
6
9-89

DEC 16 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER002

210

M132169

70

M132381

70

M135718

70

ST347

60

M131856

60

NAS1149C0363R

Purchased

No

110

Each

450.0000

4

24

NAS1149C0363R

Washer

**

DAS
6
9-89

DEC 16 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

229

m133077

229

GA

185

m133077

185

ST266

36

m135945

36

Friday, December 09, 2016 10:50:31 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

Picklist Print

Friday, December 09, 2016 10:50:31 AM

Page 3

Work Order ID: 151772

Parent Item: D206-648-013

Parent Item Name: Ground Handling Wheel Modification

151772

D206-648-013

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 6.00

Required Qty: 6.00

MS21043-3

Purchased

No

110

Each

1,436.000

4

24

MS21043-3

Nut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK007	400	
m135864	400	
FG	80	
103691	80	
FP001	411	
m130673	11	
m136182	400	
GA	39	
m133990	39	
OVER007	400	
m136295	400	
ST302	37	
m135704	37	
ST304	69	
m131340	69	

DAS
6
89

DEC 16 2016

24

mt

Friday, December 09, 2016 10:50:31 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																					

Work Order ID 151772

Friday, December 16, 2016 7:35:51 AM

151772

Item ID: D206-648-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Ground Handling Wheel Modification

Stop

NS2

Start Date: 10/3/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/7/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-648	Rev B								

100 Document Control 0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-648-013
CHG002

DAS
21
9-89

DEC 16 2016

6

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.03

Quality Control

REFERENCE ONLY

FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE
DART INSTALLATION INSTRUCTIONS.

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D206-648-011	GROUND HANDLING KIT
	X	D206-648-013	GROUND HANDLING KIT
8	8	D2652	BUSHING
2		D2659	GHW LUG
	2	D3414-041	LUG ASSEMBLY
4		AN3-37A	BOLT
	4	AN3C37A	BOLT
	4	AN960C10	WASHER
4		AN960JD10	WASHER
4		MS21042-3	NUT (OR MS21042L3)
	4	MS21043-3	NUT

RELEASED
09/02/16

B	INSTALLATION AND WEIGHT AND BALANCE INFORMATION TRANSFERRED TO DART INSTALLATION INSTRUCTIONS D206-642. ALL HARDWARE UPDATED TO SS HARDWARE.		AJS	08.09.24
A	NEW ISSUE		JB	97.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.	N/A	D206-648	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		GND HANDLING WHEEL (GHW) INSTL	NONE	
DATE	08.09.24		COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	